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REVISION				REVISION			
REV.	DESCRIPTION	DATE	APPROVED	REV.	DESCRIPTION	DATE	APPROVED
F	INCORPORATED ECN 05991	06-22-18	P. BRAVO	NC	INITIAL RELEASE	12-22-2008	P. BRAVO
G	INCORPORATED ECN 06076	08-27-18	P. BRAVO	A	INCORPORATED ECNS 02438,02465,02634 AND 02689	11-23-2009	P. BRAVO
H	INCORPORATED ECN 06202	04-29-19	P. BRAVO	B	INCORPORATED ECNS 02714, 02738, 02783, 04835	02-09-2015	P. BRAVO
J	INCORPORATED ECN 06519	10-16-20	J. GARDINER	C	INCORPORATED ECNS 05402 & 05532	08-15-2016	P. BRAVO
K	INCORPORATED ECN 06708	06-02-21	J.GARDINER	D	INCORPORATED ECNS 05734, 05782, 05837	08-16-17	P. BRAVO
				E	INCORPORATED ECN 05837	04-05-18	P. BRAVO

NOTES:

1. TOLERANCES IAW MPP-54, UNLESS OTHERWISE NOTED.
2. SUGGESTED VENDOR: MIRADA RESEARCH AND MANUFACTURING INC.
3. STENCIL DATA SHALL BE READ WHEN FACING DIRECTION AS INDICATED AND LOCATED APPROXIMATELY WHERE SHOWN WITH F/N 35.
4. MATERIAL: P/N 600.0065, SEE SPEC AMS-028.
5. ALL DOUBLERS TRIM TO FIT.
6. MATERIAL: FOR P/N 600.0025, SEE SPEC AMS-021 REV N/C.
7. IDENTIFY IAW MPP-120.
8. INSTALL F/N 67 ON AFT SIDE ONLY
9. ONLY CEMENT THE PERIMETER OF THE DOUBLER, MINIMUM OF 1.0 IN WHERE POSSIBLE
10. HOT AIR WELD SEAMS IAW MPP-057.
11. P/N 646.5455 OUTER CONE DOUBLER, ORIGINALLY PART OF ASSEMBLIES .5457 & .5458 FOR INCREASED GROSS WEIGHT, HAS BEEN REMOVED. THE .5457 & .5458 FLOAT ASSYS ARE THE SAME AS THE .5403 & .5404 ASSYS.
12. ARC LENGTH FROM SEAM TO PATCH (F/N 57 & 58) LOCATION.

1									1				33	646.5440	PANEL CENTER - FWD R.H.		
1									1				32	646.5439	PANEL AFT - OUTER BAG R.H.		
1									1				31	646.5438	PANEL FWD - OUTER BAG R.H.		
1									1				30	646.5437	CONE - OUTER R.H.		
	1									1			29	646.5436	PANEL AFT - INNER BAG L.H.		
	1									1			28	646.5435	PANEL AFT - CENTER BAG L.H.		
	1									1			27	646.5434	PANEL AFT - OUTER BAG L.H.		
													26		DELETED		
													25		DELETED		
													24		DELETED		
													23		DELETED		
													22		DELETED		
8	8								8	8			21	646.5426	X-HINGE TAPE		
2	2								2	2			20	646.5425	DOUBLER BOTTOM -BAGS		
						1							19	646.5424	DOUBLER CENTER - GIRT		
						2							18	646.5423	DOUBLER - GIRT		
						1							17	646.5422	GIRT TOP PANEL		
						1							16	646.5421	GIRT PANEL		
2	2								2	2			15	646.5419	OUTER BAG END CAP		
2	2								2	2			14	646.5418	INNER BAG END CAP		
4	4								4	4			13	646.5417	CENTER CAP PANEL		
1	1								1	1			12	646.5416	ENDCAP INNER CONE		
2	2								2	2			11	646.5415	ENDCAP OUTER CONE		
	1									1			10	646.5414	OUTER CONE L.H.		
	1									1			9	646.5413	INNER CONE L.H.		
	1									1			8	646.5412	INNER BAG PANEL FWD L.H.		
	1									1			7	646.5411	OUTER BAG PANEL FWD L.H.		
	1									1			6	646.5456	CENTER PANEL FWD L.H.		
								1			1		5	645.1904-106	-6 DUAL INLET CHECK VALVE (.106)		
3	3								3	3			4	600.0205	FLUSH FLANGE	B-51073 REV D	
3	3								3	3			3	600.0206	RECESSED FLANGE	B-51242 REV C	
							1					1	2	645.1825-192	-6 SINGLE INLET CHECK VALVE(.192)		
		3	3	3	3		3	3			3	3	1	601.1447	PRV/TOPPING VALVE	A-53001-S REV N/C	
X		1		1										646.5458	FLOAT R.H. BAG		
	X		1		1									646.5457	FLOAT L.H. BAG		
		X												646.5454	FWD FLOAT ASSY R.H W/ GUARD		
			X											646.5453	FWD FLOAT ASSY L.H W/ GUARD		
				X										646.5452	FWD FLOAT ASSY R.H.		
					X									646.5451	FWD FLOAT ASSY L.H.		
1	1					X			1	1				646.5450	GIRT ASSY		
							X							646.5406	FWD FLOAT ASSY L.H W/GUARD		
								X						646.5405	FWD FLOAT ASSY R.H W/ GUARD		
								1	X		1			646.5404	FLOAT R.H. BAG		
										X		1		646.5403	FLOAT L.H. BAG		
											X			646.5402	FWD FLOAT ASSY R.H.		
												X		646.5401	FWD FLOAT ASSY L.H.		
.5458	.5457	.5454	.5453	.5452	.5451	.5450	.5406	.5405	.5404	.5403	.5402	.5401					

CONFIGURATION TABLE					
KIT P/N	DESCRIPTION	BASE BOM	DELETE	ADD	NOTES
646.5407	EC145 T2 FWD FLOAT ASSY LH	646.5401	645.1905 645.1904-156 645.1825-192	645.1825-213 645.1904-177 645.1904-250	645.1825-213 in Fwd Chamber 645.1904-177 in Mid Chamber 645.1904-250 in Aft Chamber
646.5408	EC145 T2 FWD FLOAT ASSY RH	646.5402	645.1825-125 645.1904-106 645.1904-141	645.1825-141 645.1904-115 645.1904-156	645.1824-141 in Fwd Chamber 645.1904-115 in Mid Chamber 645.1904-156 in Aft Chamber
646.5409	EC145 T2 FWD FLT ASSY L.H W/GUARD	646.5406	645.1905 645.1904-156 645.1825-192	645.1825-213 645.1904-177 645.1904-250	645.1825-213 in Fwd Chamber 645.1904-177 in Mid Chamber 645.1904-250 in Aft Chamber
646.5410	EC145 T2 FWD FLT ASSY R.H W/GUARD	646.5405	645.1825-125 645.1904-106 645.1904-141	645.1825-141 645.1904-115 645.1904-156	645.1824-141 in Fwd Chamber 645.1904-115 in Mid Chamber 645.1904-156 in Aft Chamber

QTY

F/N

P/N

DESCRIPTION

MAT'L

SPEC

NEXT ASSY (\$)

646.4100

654.6700

ORIGINAL DATE (MO-DA-YR) 11-15-2008
DRAWN BY DP 11-15-2008
CHECKER P. BRAVO 12-22-2008
DRAWING APPROVAL PB 12-22-2008
CONTRACT No.

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.02
3 PLACE DECIMALS ±.030
ANGLES ±.5°

DART AEROSPACE

APICAL INDUSTRIES, INC.

dba DART AEROSPACE

3030 ENTERPRISE CT., SUITE A
VISTA, CA. 92081
(760)-724-5300

FWD FLOAT ASSY

SIZE B

CAGE CODE 07MZ6

DWG. NO. 646.5400

REV. K

SCALE NONE

SHEET 1 OF 6

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A

B

C

D

			1		1								76	645.1904-250	-6 DUAL INLET CHECK VALVE(.250)		
		1		1									75	645.1904-115	-6 DUAL INLET CHECK VALVE(.115)		
			1		1								74	645.1904-177	-6 DUAL INLET CHECK VALVE(.177)		
		1		1									73	645.1825-141	-6 SINGLE INLET CHECK VALVE(.141)		
			1		1								72	645.1825-213	-6 SINGLE INLET CHECK VALVE(.213)		
			1				1						71	646.5608	COVER FWD L.H W/ GUARD		
1	1								1	1			70	646.5449	INNER DOUBLER AFT	<div>6</div>	
1	1								1	1			69	646.5448	INNER DOUBLER FWD	<div>6</div>	
		4	4	4	4		4	4			4	4	68	601.0785	BOLT	AN3C6A	
4	4								4	4			67	647.2702	SANDWICH SPLIT PATCH		
1	1								1	1			66	646.5445	INNER CONE DOUBLER	<div>6</div>	
							1				1		65	645.1825-125	-6 SINGLE INLET CHECK VALVE(.125)		
		1		1			1					1	64	645.1904-156	-6 DUAL INLET CHECK VALVE(.156)		
		1						1					63	646.5607	COVER FWD R.H W/ GUARD		
							1					1	62	645.1905	-6 INLET CHECK VALVE		
								1			1		61	645.1904-141	-6 DUAL INLET CHECK VALVE(.141)		
		2	2	2	2		2	2			2	2	60	646.5711	CHANNEL		
						1							59	646.5310	GIRT		
2	2								2	2			58	20370-2	VELCRO PATCH		
2	2								2	2			57	20370-1	VELCRO PATCH		
5 YD	5 YD								5 YD	5 YD			56		TAPE 2.0" BIAS	<div>4</div>	
				1							1		55	646.5604	COVER, FWD R.H.		
					1							1	54	646.5603	COVER, FWD L.H.		
5 YD	5 YD								5 YD	5 YD			53		TAPE 3.0"	<div>4</div>	
		16	16	16	16		16	16			16	16	52	601.0789	NUT	MS21043-3	
		32	32	32	32		32	32			32	32	51	601.0774	WASHER	NAS1149C0363R	
		12	12	12	12		12	12			12	12	50	601.0720	BOLT	AN3C5A	
A/R	A/R								A/R	A/R			49	600.0912	INK	MIL-I-6903 TYP IV BLK	
		2	2	2	2		2	2			2	2	48	602.3007	HOSE ASSY		
45 YD	45 YD								45 YD	45 YD			47		TAPE 1" BIAS	<div>4</div>	
3	3								3	3			46	20303-4	VALVE COLLAR	<div>4</div>	
4	4								4	4			45	20443-1	COMM FLANGE ASSY	<div>4</div>	
3	3								3	3			44	20441-1	DIFFUSER	<div>4</div>	
3	3								3	3			43	20304-1	CHAFE GUARD	<div>4</div>	
3	3								3	3			42	20303-2	VALVE COLLAR	<div>4</div>	
3	3								3	3			41	20303-1	VALVE COLLAR	<div>4</div>	
													40		DELETED		
20	20								20	20			39	647.2701	SPLIT PATCH	<div>4</div>	
3	3								3	3			38	20303-3	VALVE COLLAR	<div>4</div>	
1									1				37	646.5444	PANEL INNER BAG - AFT R.H.	<div>4</div>	
1									1				36	646.5443	PANEL INNER BAG - FWD R.H.	<div>4</div>	
1									1				35	646.5442	CONE INNER R.H.	<div>4</div>	
1									1				34	646.5441	PANEL CENTER - AFT R.H.	<div>4</div>	
.5458	.5457	.5454	.5453	.5452	.5451	.5450	.5406	.5405	.5404	.5403	.5402	.5401					
QTY													F/N	PART No.	DESCRIPTION	MAT'L	SPEC

ORIGINAL DATE
(MO-DA-YR) 11-15-2008

DRAWN BY
DP 11-15-2008

CHECKER
P. BRAVO 12-22-2008

DRAWING APPROVAL
PB 12-22-2008

CONTRACT No.

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.005
ANGLES ±.5°

DART
AEROSPACE

APICAL INDUSTRIES, INC.
dba DART AEROSPACE

3030 ENTERPRISE CT.,
SUITE A
VISTA, CA. 92081
(760)-724-5300

SIZE
B

CAGE CODE
07MZ6

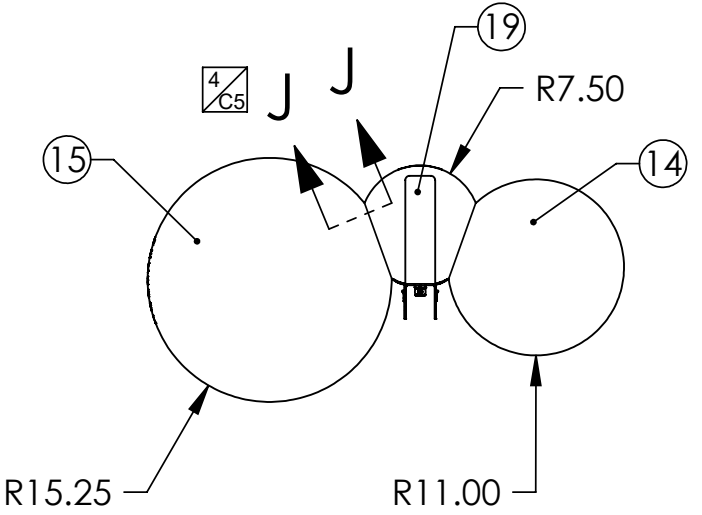
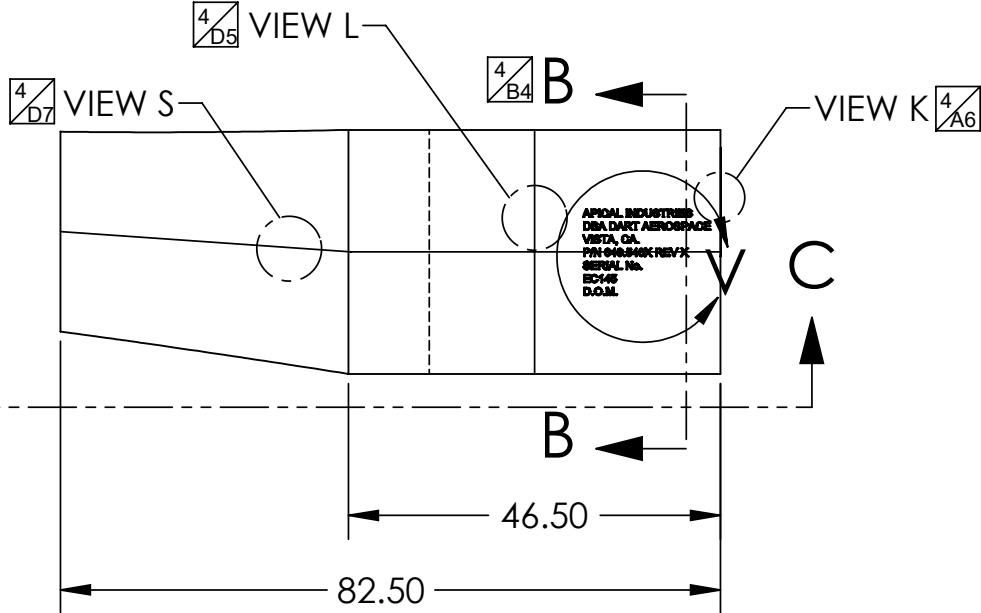
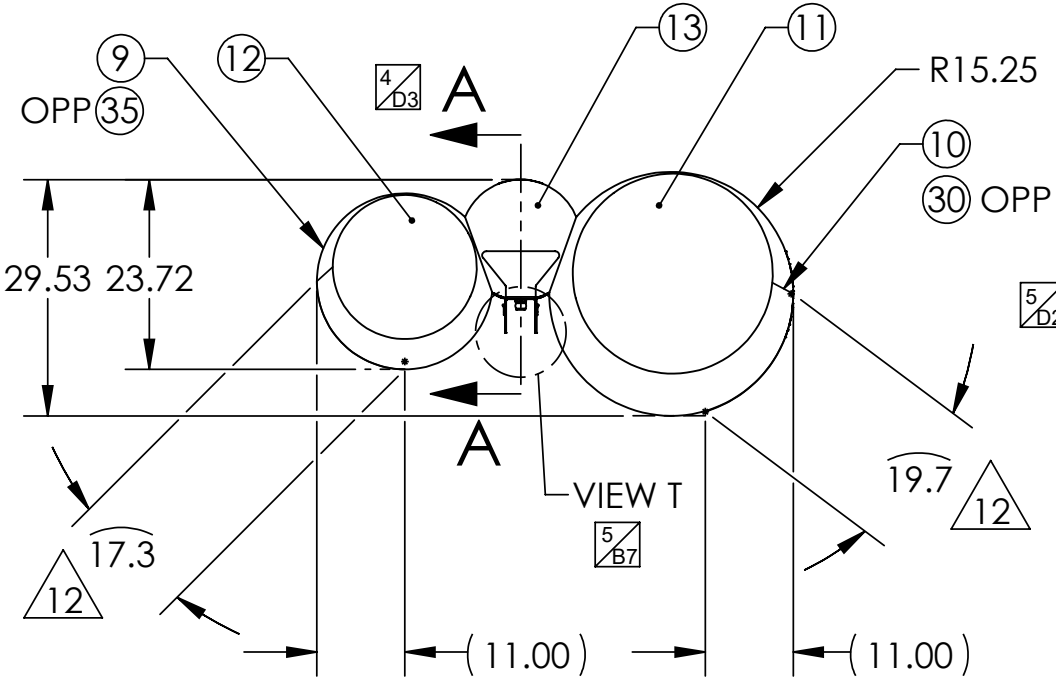
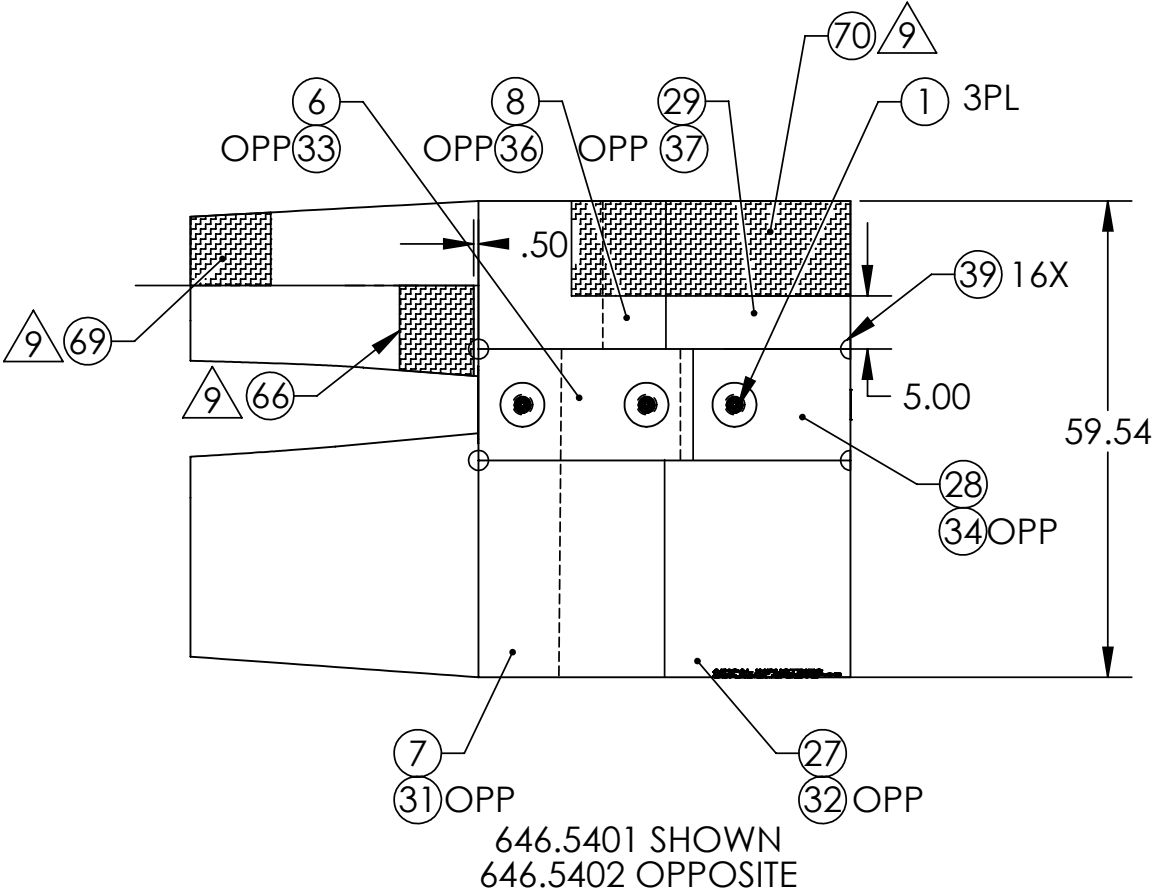
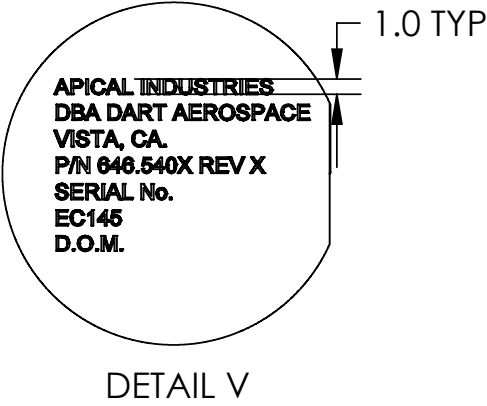
DWG. NO.
646.5400

REV.
K

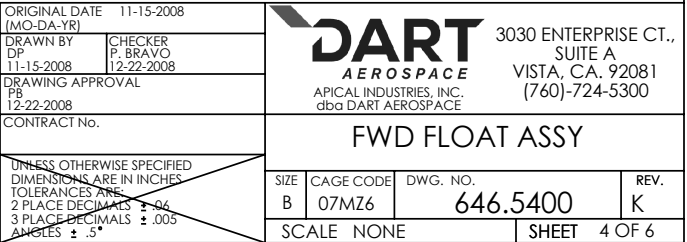
SCALE NONE

SHEET 2 OF 6

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ORIGINAL DATE (MO-DA-YR) 11-15-2008	3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300
DRAWN BY DP 11-15-2008	CHECKER P. BRAVO 12-22-2008
DRAWING APPROVAL PB 12-22-2008	APICAL INDUSTRIES, INC. dba DART AEROSPACE
CONTRACT No.	FWD FLOAT ASSY
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°	SIZE B 07MZ6 DWG. NO. 646.5400 REV. K
	SCALE NONE SHEET 3 OF 6



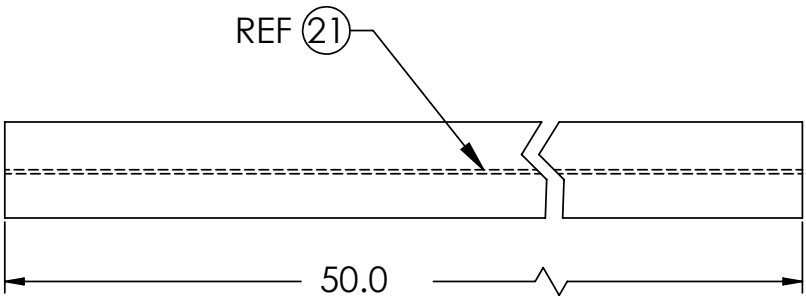
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A

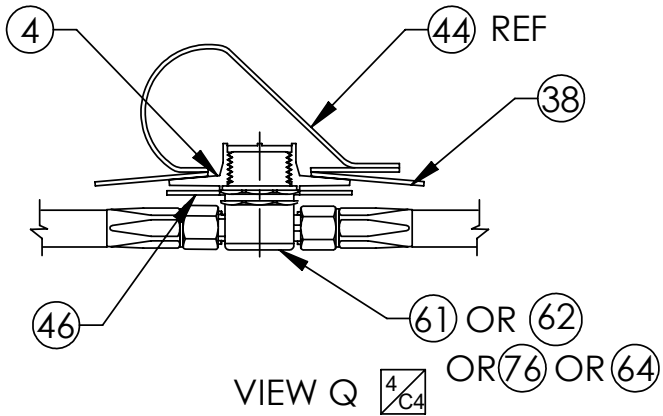
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C

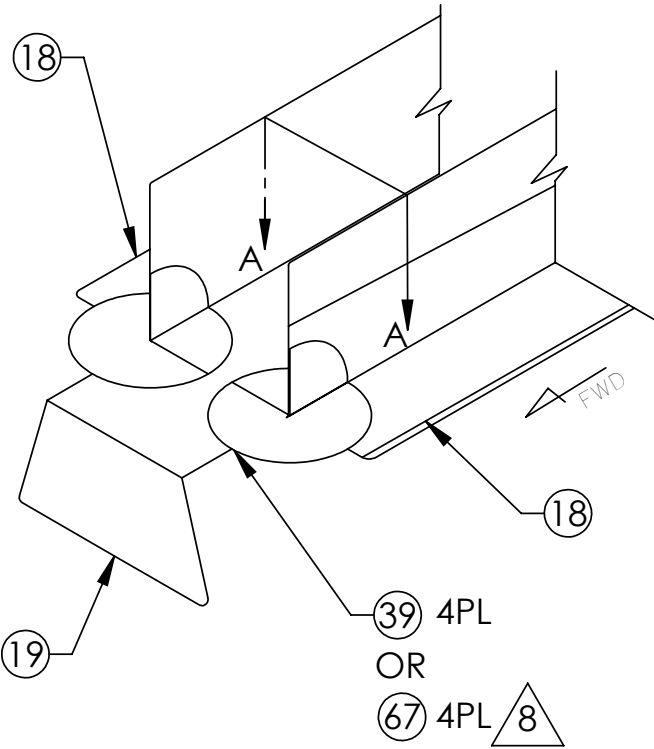
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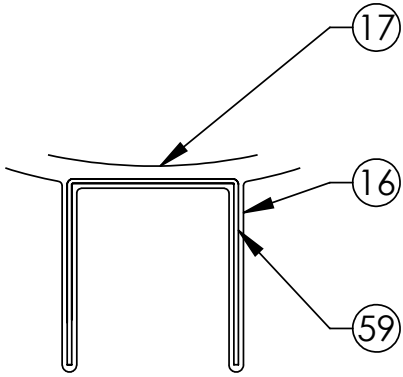
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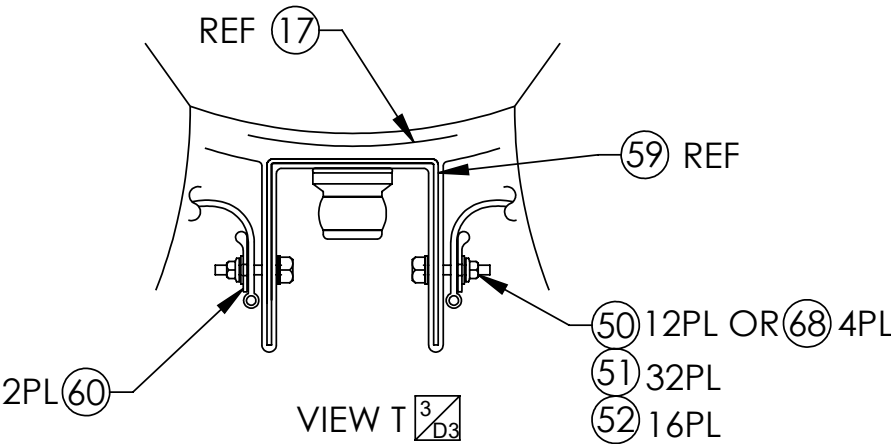
VIEW Q 4x4



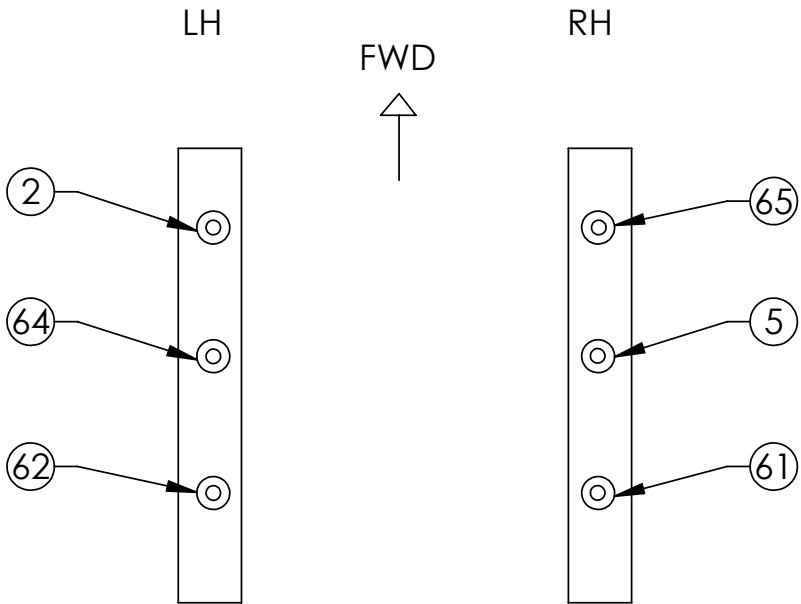
SECTION R-R ROTATED IN ISO
REMOVED FLOAT FOR CLARITY



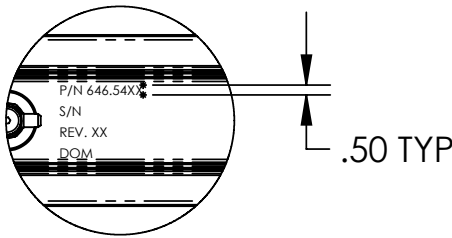
SECTION A-A
646.5411
GIRT SUB ASSY



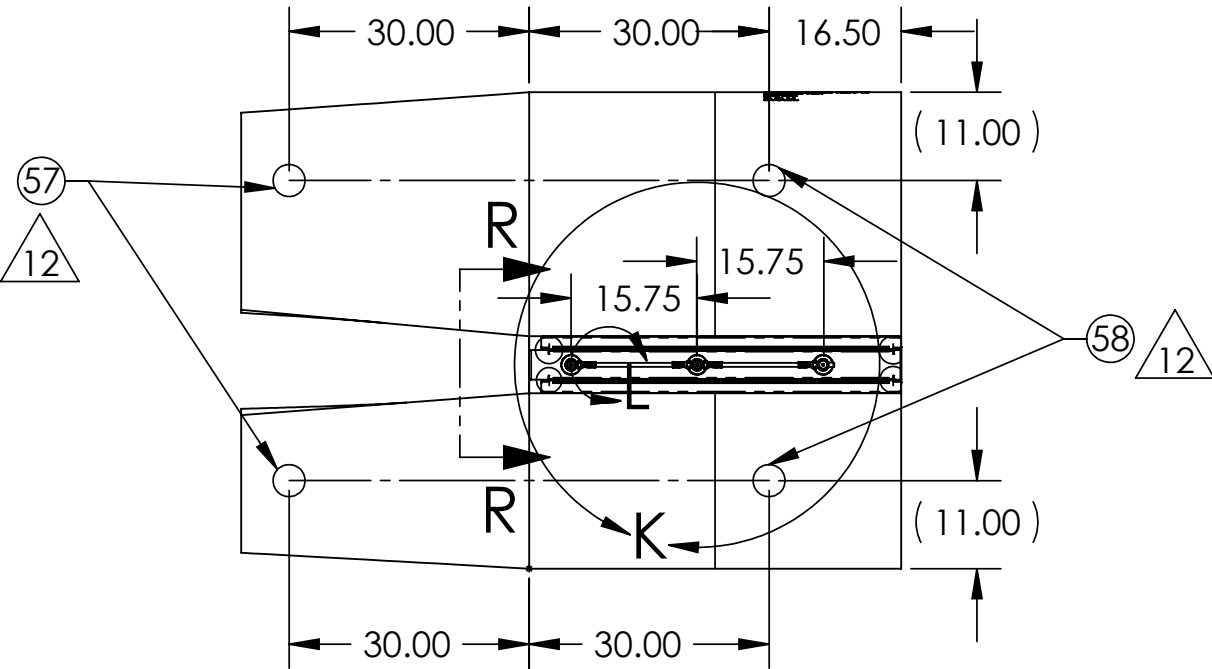
VIEW T 3x3



DETAIL K
INLET CHECK VALVE INSTALLATION INSTRUCTION



DETAIL L
646.5401 SHOWN
646.5402 OPP



SECTION C-C

3x3

ORIGINAL DATE (MO-DA-YR) 11-15-2008	CHECKER P. BRAVO 12-22-2008	3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY DP 11-15-2008	DRAWING APPROVAL PB 12-22-2008	APICAL INDUSTRIES, INC. dba DART AEROSPACE	
CONTRACT No.		FWD FLOAT ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°	SIZE B	CAGE CODE 07MZ6	REV. K
SCALE NONE		DWG. NO. 646.5400	SHEET 5 OF 6

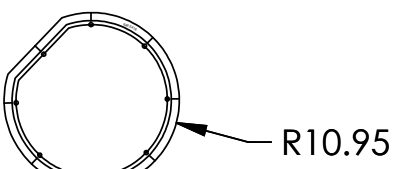
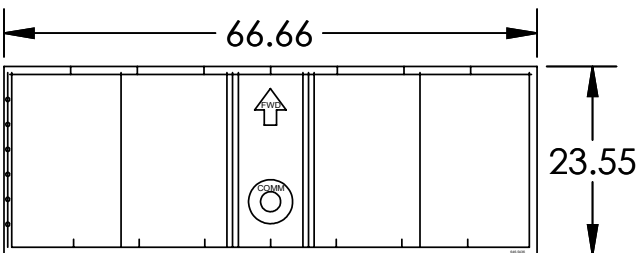
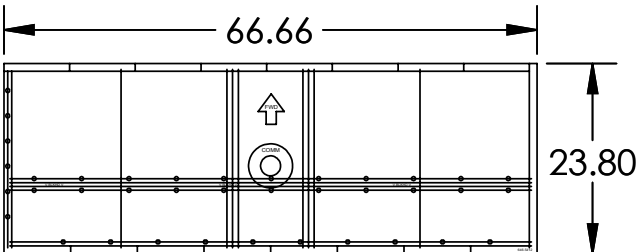
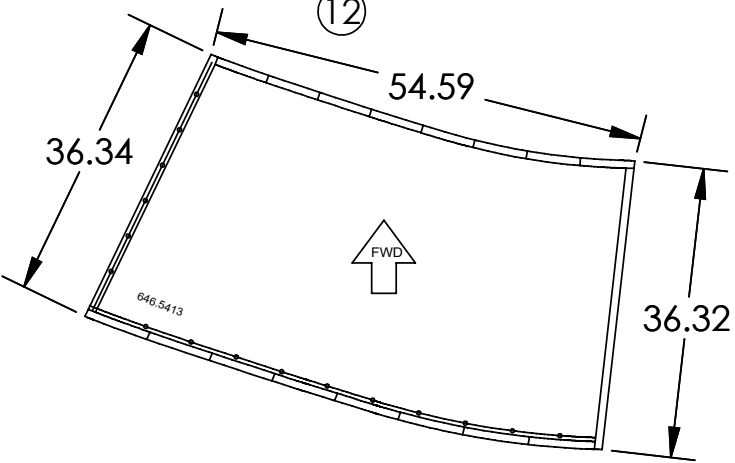
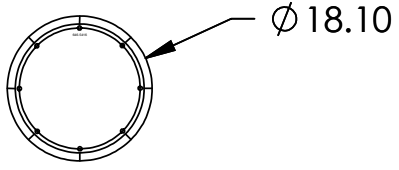
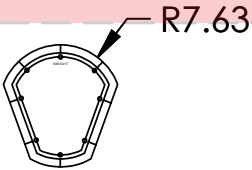
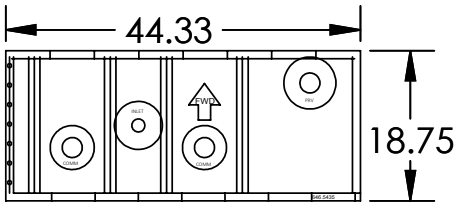
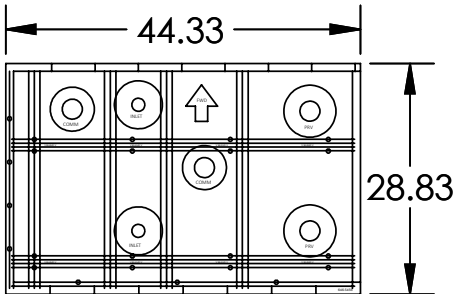
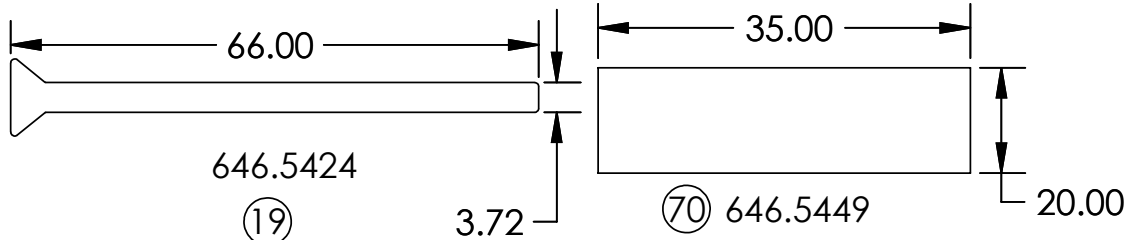
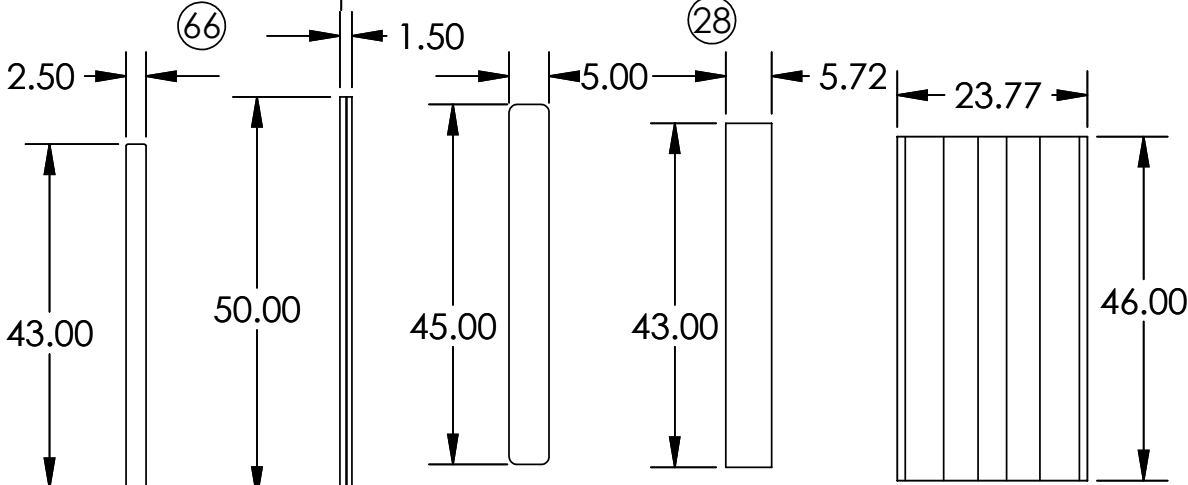
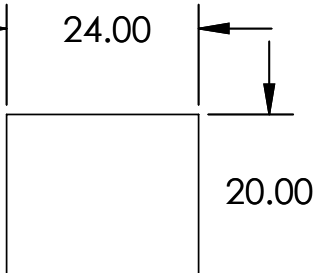
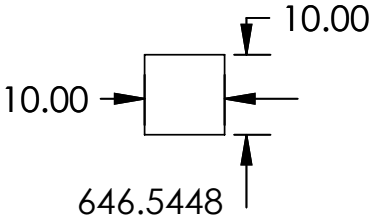
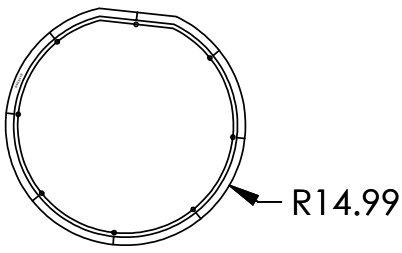
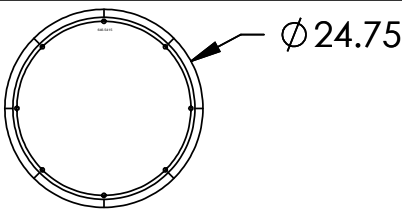
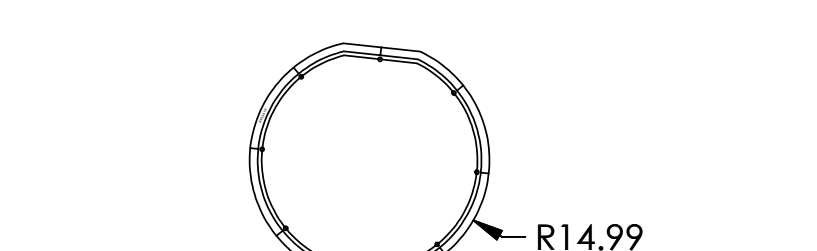
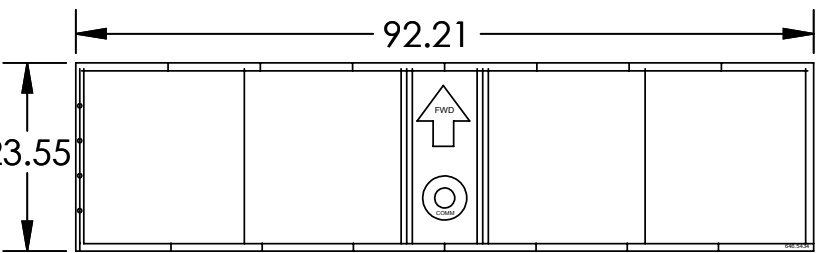
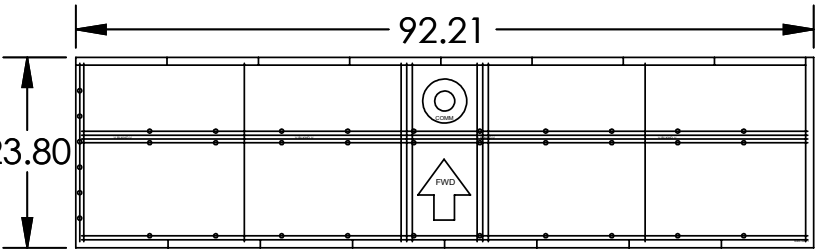
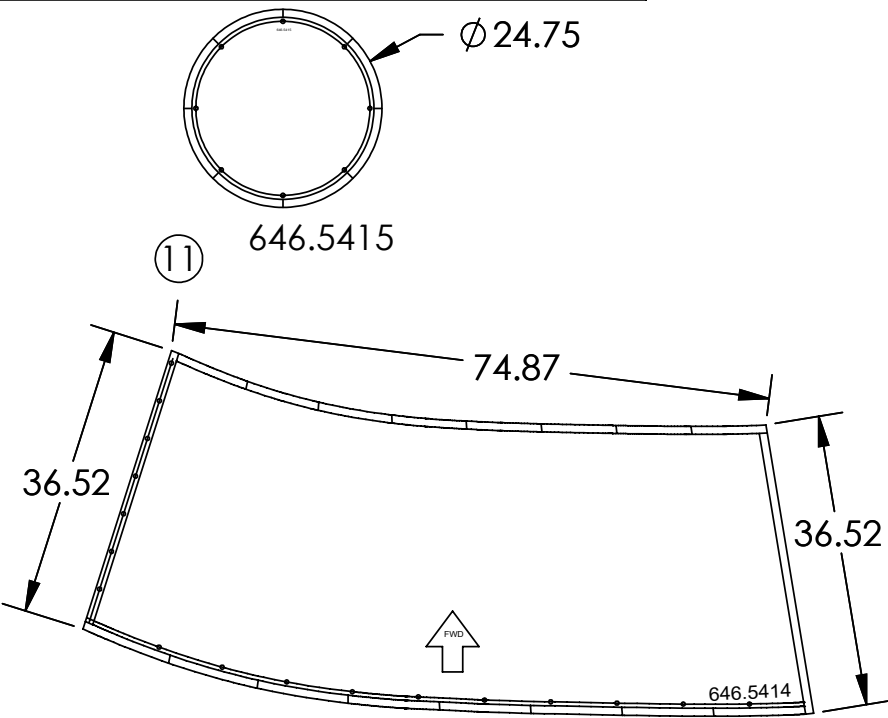
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A

B

C

D



ORIGINAL DATE (MO-DA-YR) 11-15-2008
DRAWN BY DP 11-15-2008
CHECKER P. BRAVO 12-22-2008
DRAWING APPROVAL PB 12-22-2008
CONTRACT No.

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TOLERANCES ARE:
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.005
ANGLES ±.5°

DART AEROSPACE
APICAL INDUSTRIES, INC.
dba DART AEROSPACE
3030 ENTERPRISE CT., SUITE A
VISTA, CA. 92081
(760)-724-5300

FWD FLOAT ASSY

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SCALE NONE			SHEET 6 OF 6